

Work Order ID 128224

Tuesday, January 13, 2015 1:28:52 PM

128224

Page 1

Item ID: D3535-25 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Center
 Start Date: 1/13/2015 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 1/20/2015 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 15-01-14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3535	Rev B

100	FLOW WATER JET	0.00				25	Ø		Jm 15-1-14
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3535 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-								
304 . 040	Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00				25	Ø		Jm 15-1-14
110									
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00				25			DAS 38 9-89
120									
QC	Memo	0.00							
Quality Control									

JAN 15 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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 Start Date: 1/13/2015 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 1/20/2015 Req'd Qty: 16.00 ***16*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo 1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261 and DT83262- Form joggle on Punch as per Dwg D3535 using Jig DT8158 Identify as D3535-25	0.00 0.00			DAS 30 9-89	25			15/01/20
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				25			DAS 30 9-89 JAN 20 2015
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 7:40. OVEN TEMPERATURE: FINISH TIME: 8:10.	0.00 0.00				25			DAS 30 9-89

DQA: _____ Date: _____



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Doc/Data									
Equip/Tooling									
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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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1 28224

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/13/2015 **Start Qty:** 16.00

16

Cust Item ID:

Required Date: 1/20/2015 **Req'd Qty:** 16.00

16

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

[illegible]

JAN 22 2015

x25 of 15/06/22

MLS 1501-23

MF

15-1-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Tuesday, January 13, 2015 1:28:54 PM

Page 1

Work Order ID: 128224

128224

Parent Item: D3535-25

D3535-25

Parent Item Name: Wearplate Center

Start Date: 1/13/2015

Required Date: 1/20/2015

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	235.7639	0.51	9			

M304S20GA

304/316 .040 Sheet

Jm 15-1-14.

Location

Loc Qty

Loc Code

MAT020

235.7639

m130345

3.7639

m131060

232

131060.

DQA: _____ Date: _____



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Operator									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

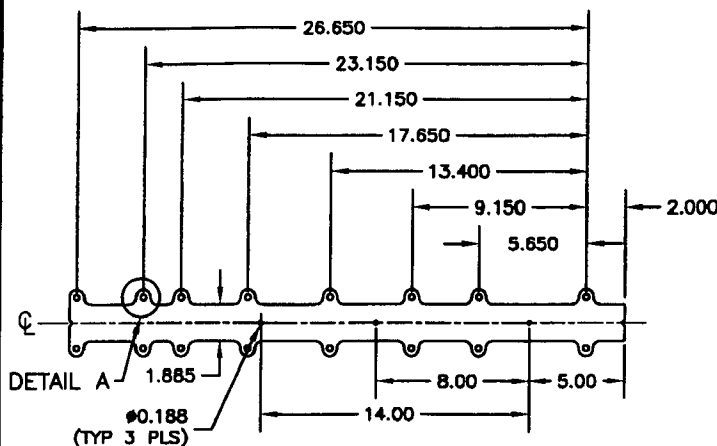
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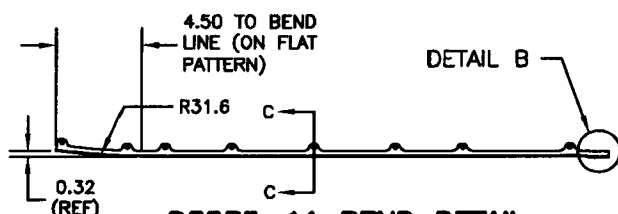
RELEASED
07.04.24

SHOP COPY
RETURN TO
ENGINEERING
FOR CONTROLLED COPY
DATE OF AMENDMENT
DATE OF ISSUE
VOLUME NUMBER
128224 MLS
15-01-14

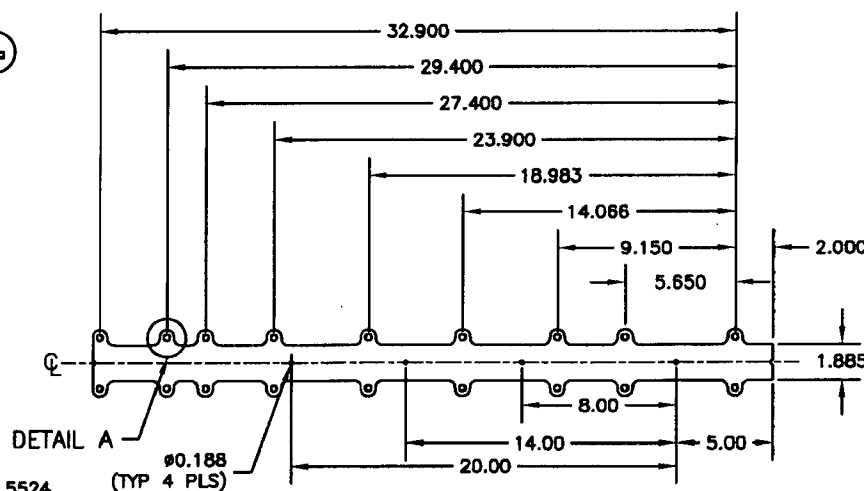
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		
		SCALE	1:10	
		SHEET 1 OF 7		
		REV. B		



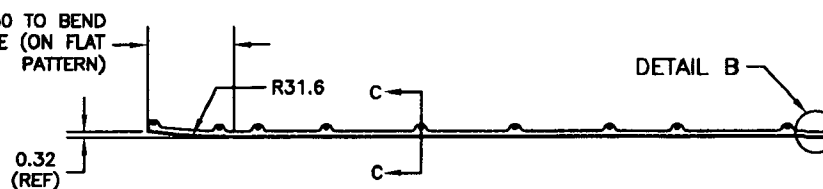
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

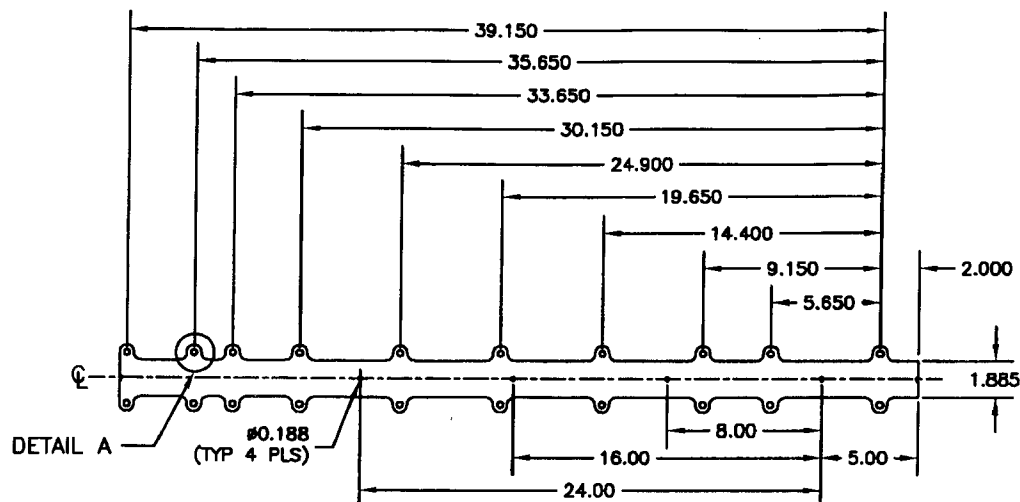
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

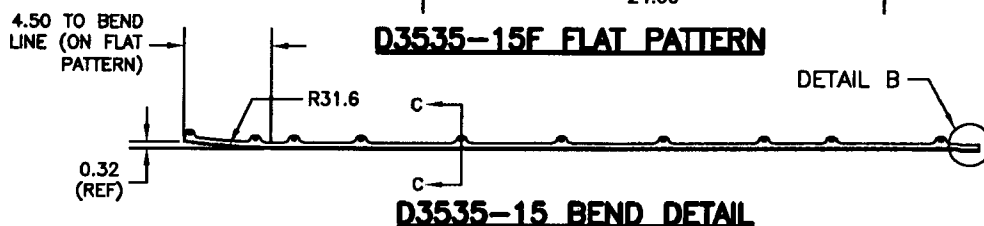
DART

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07.04.24

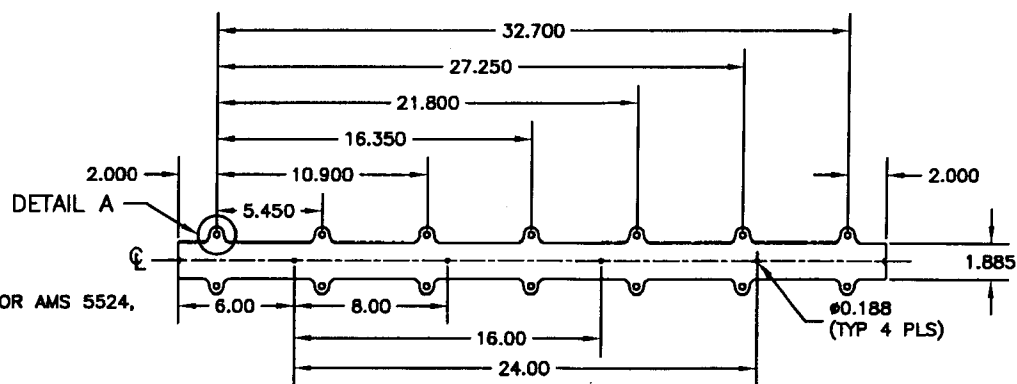
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 2 OF 7
	SCALE 1:10	



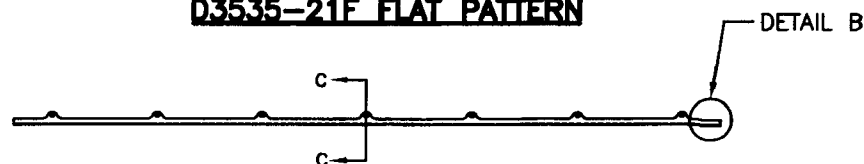
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

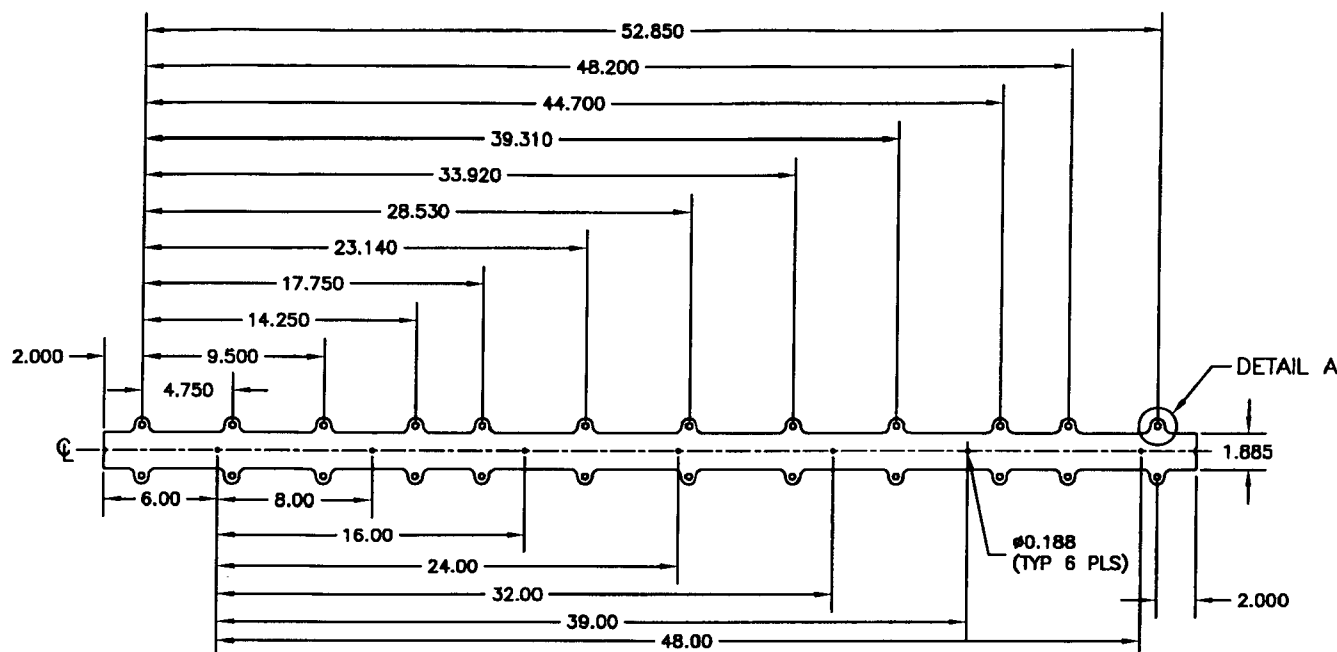
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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	REV. B
			WEARSHOE	SHEET 3 OF 7
				SCALE 1:10

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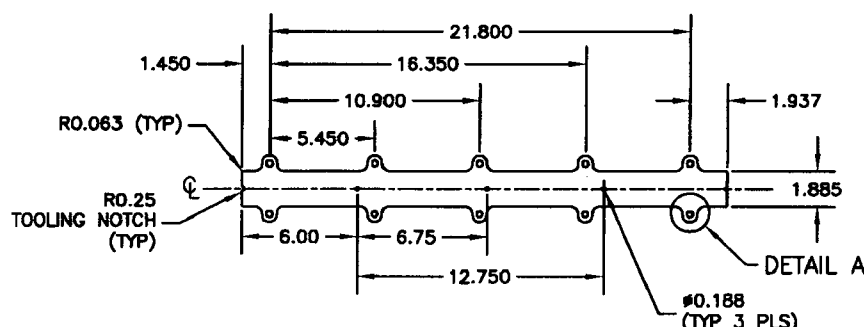
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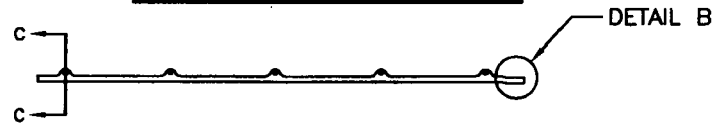
D3535-23F FLAT PATTERN



D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

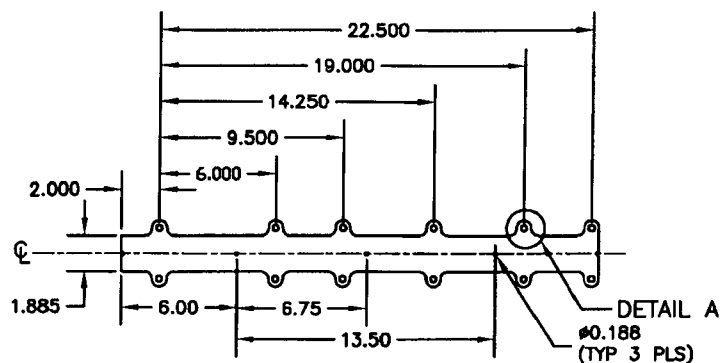
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DART

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07.04.24

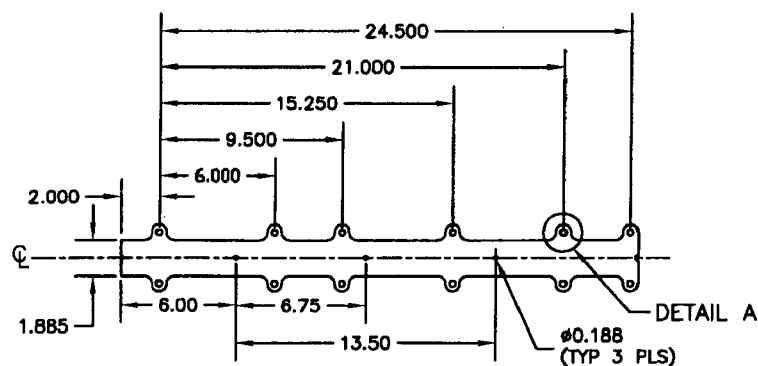
DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED 	APPROVED 	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 4 OF 7
	SCALE 1:10	



D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

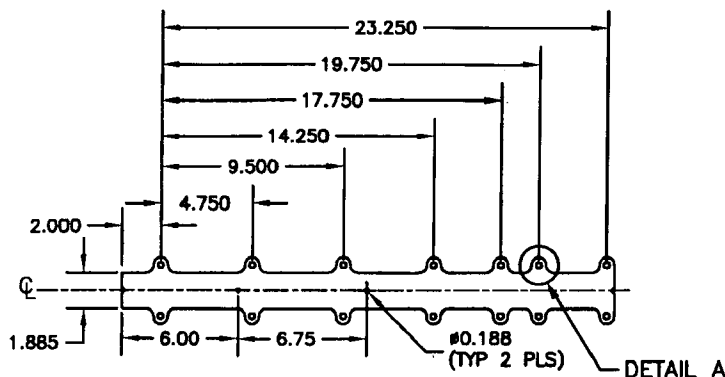
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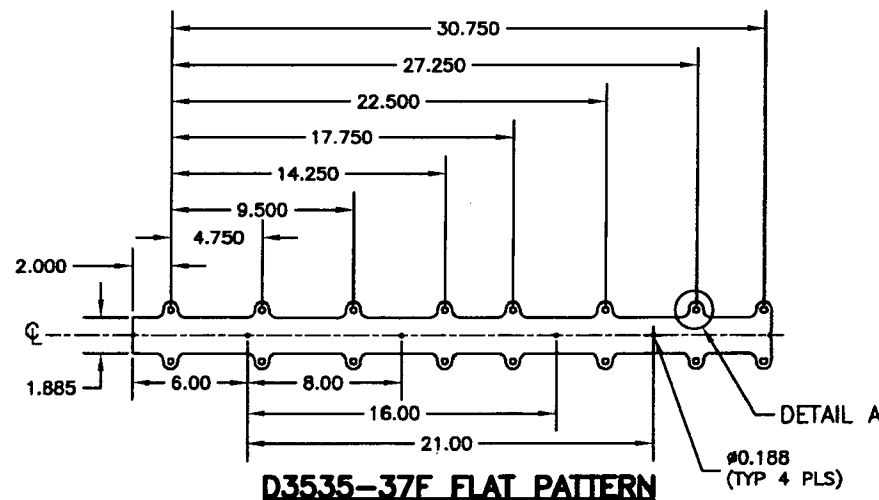
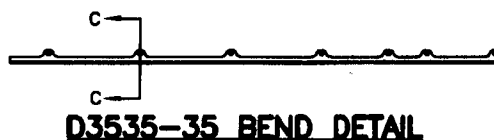
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RELEASED
07.04.17

DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 5 OF 7
		SCALE	1:10	



D3535-35F FLAT PATTERN



D3535-37F FLAT PATTERN



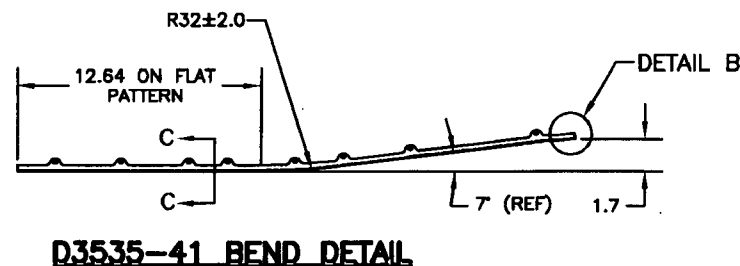
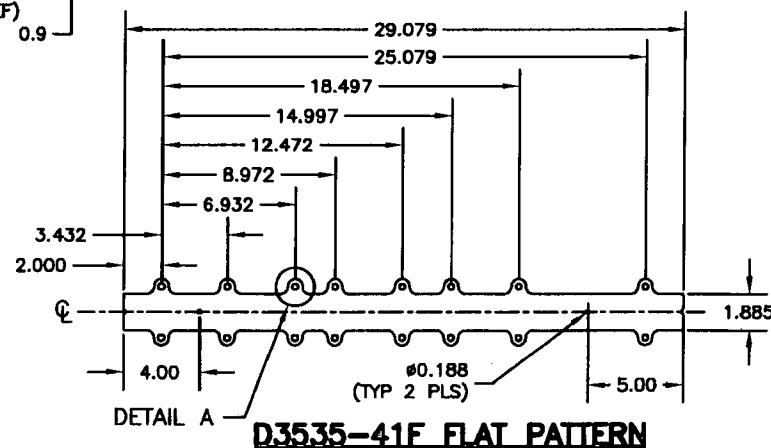
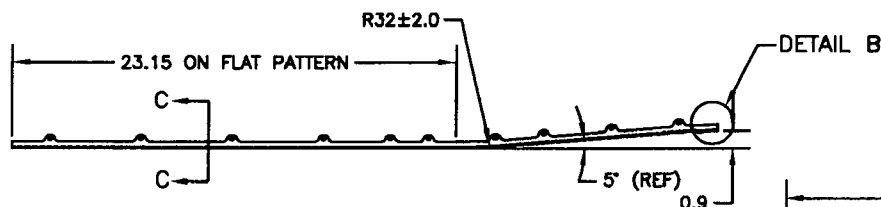
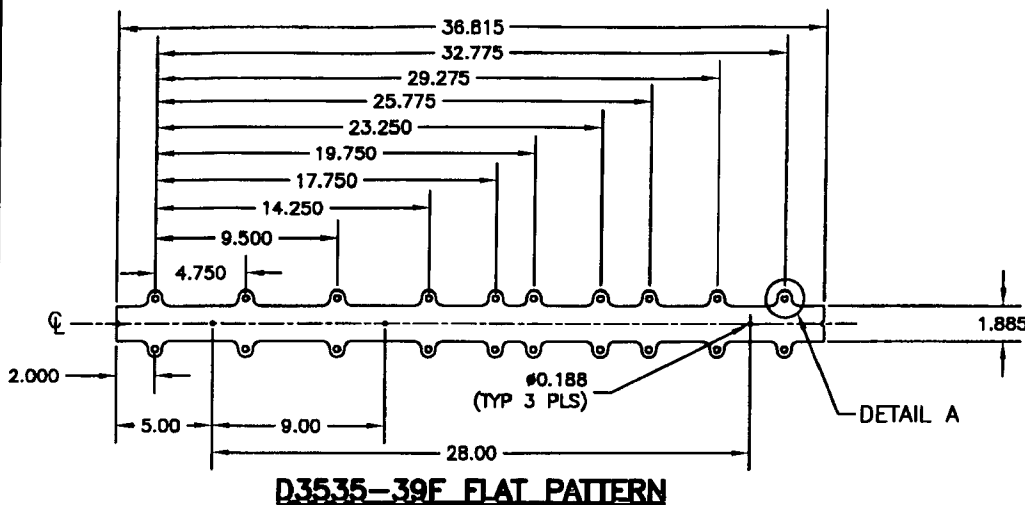
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



RELEASED
07.04.24

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 6 OF 7
		SCALE
		1:10



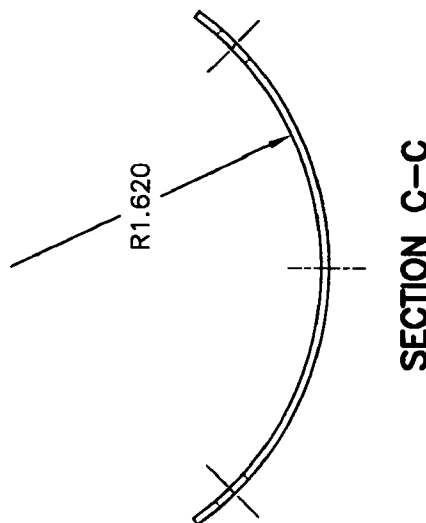
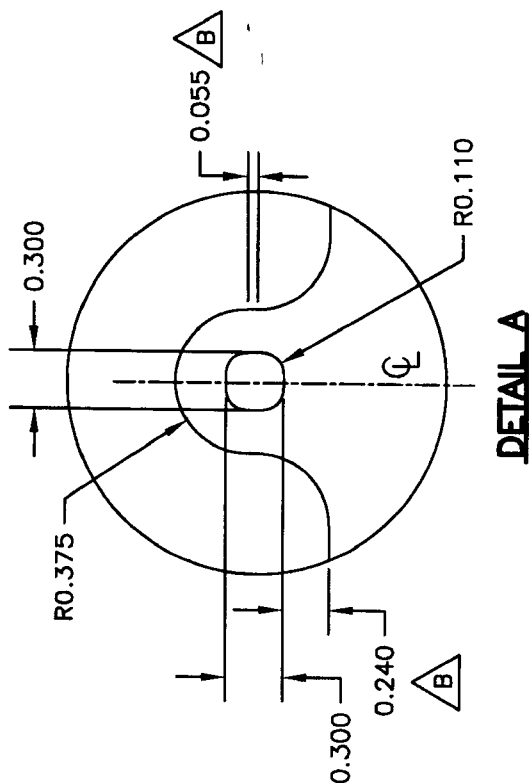
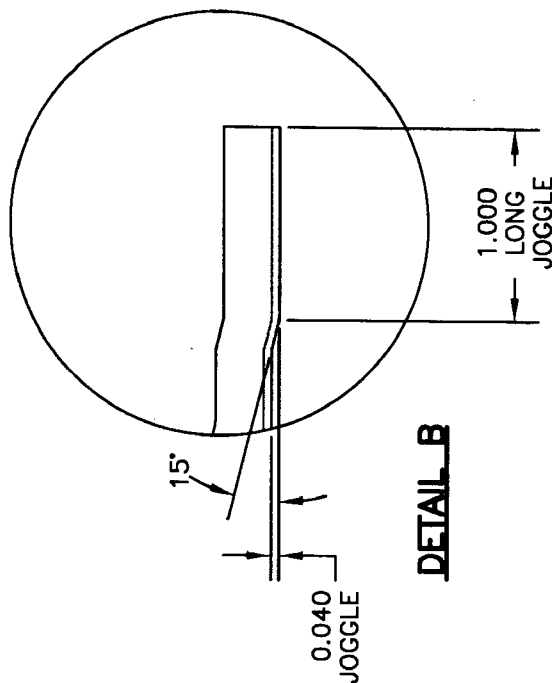
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DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

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07.04.24



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